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Wilson

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(54) **COMBINED FEATURE DIMENSIONAL
PARAMETER ANALYSIS**

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(52) **U.S. Cl.** **702/155; 703/7**

(58) **Field of Search** 702/155, 168,
702/189, 56, 40, 190; 703/7, 1; 716/21; 33/512;
74/89.14; 396/48

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Primary Examiner—Michael Nghiem

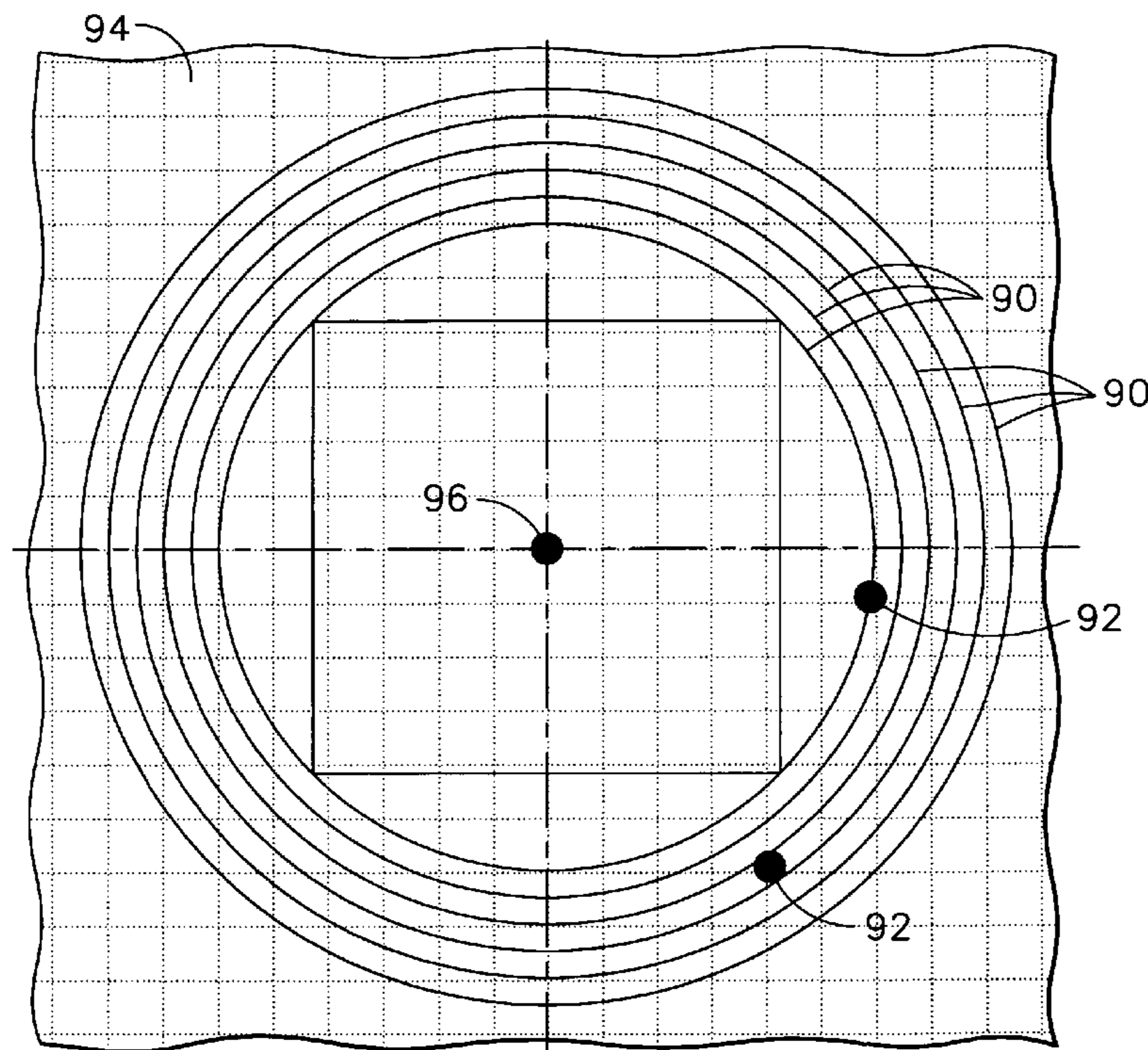
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(57) **ABSTRACT**

A computerized method is disclosed for determining the size and location effects of simulated or manufactured features on an object, determining the transformation of a pattern of features, determining usable feature size within a pattern of features, and determining the remaining feature tolerances. The simulated or manufactured position of a pattern of features is used to determine how to translate a tolerance zone framework. Positional errors and remaining feature tolerances are determined relative to the translated design framework.

41 Claims, 12 Drawing Sheets



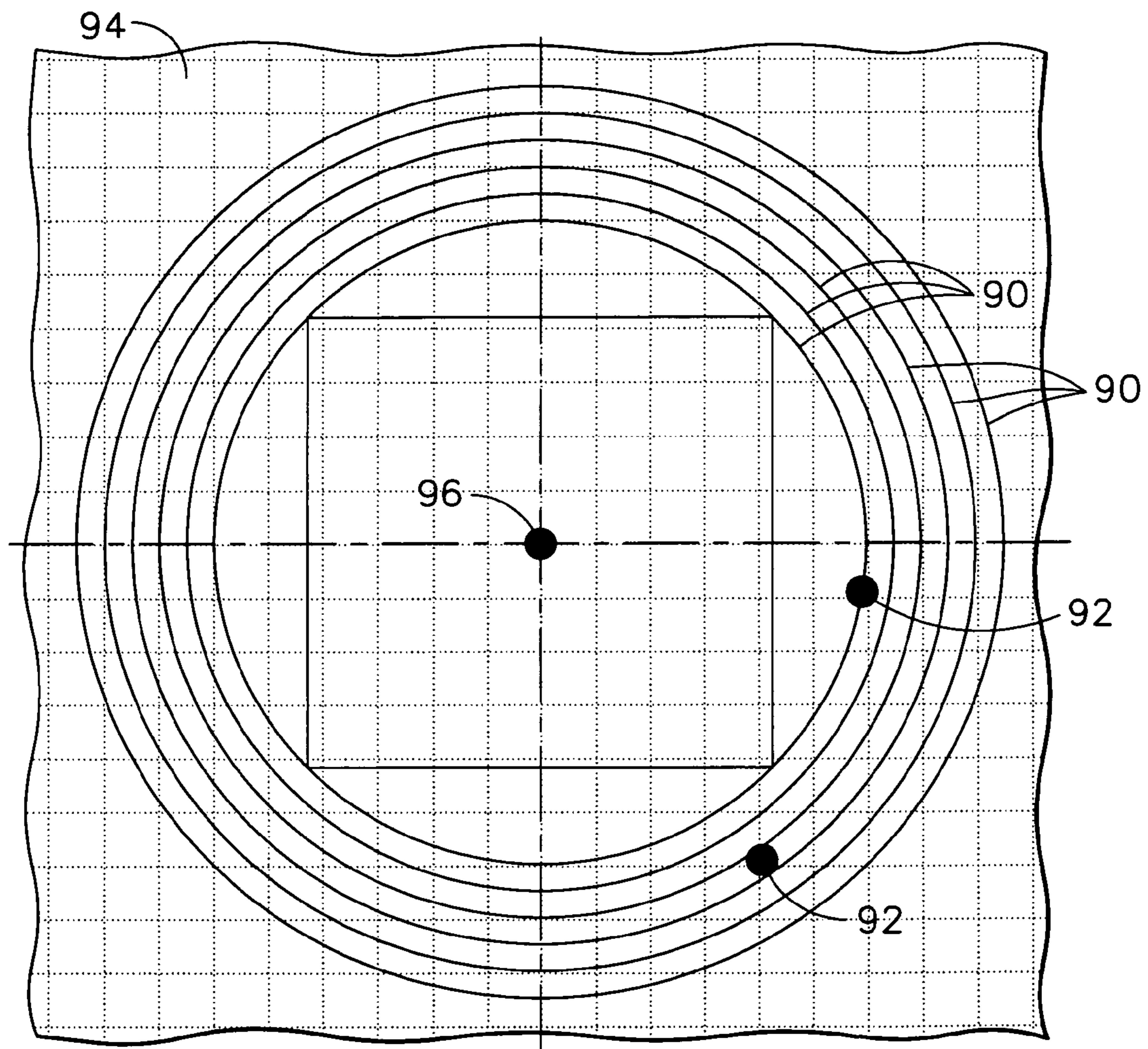


FIG. 1
(PRIOR ART)

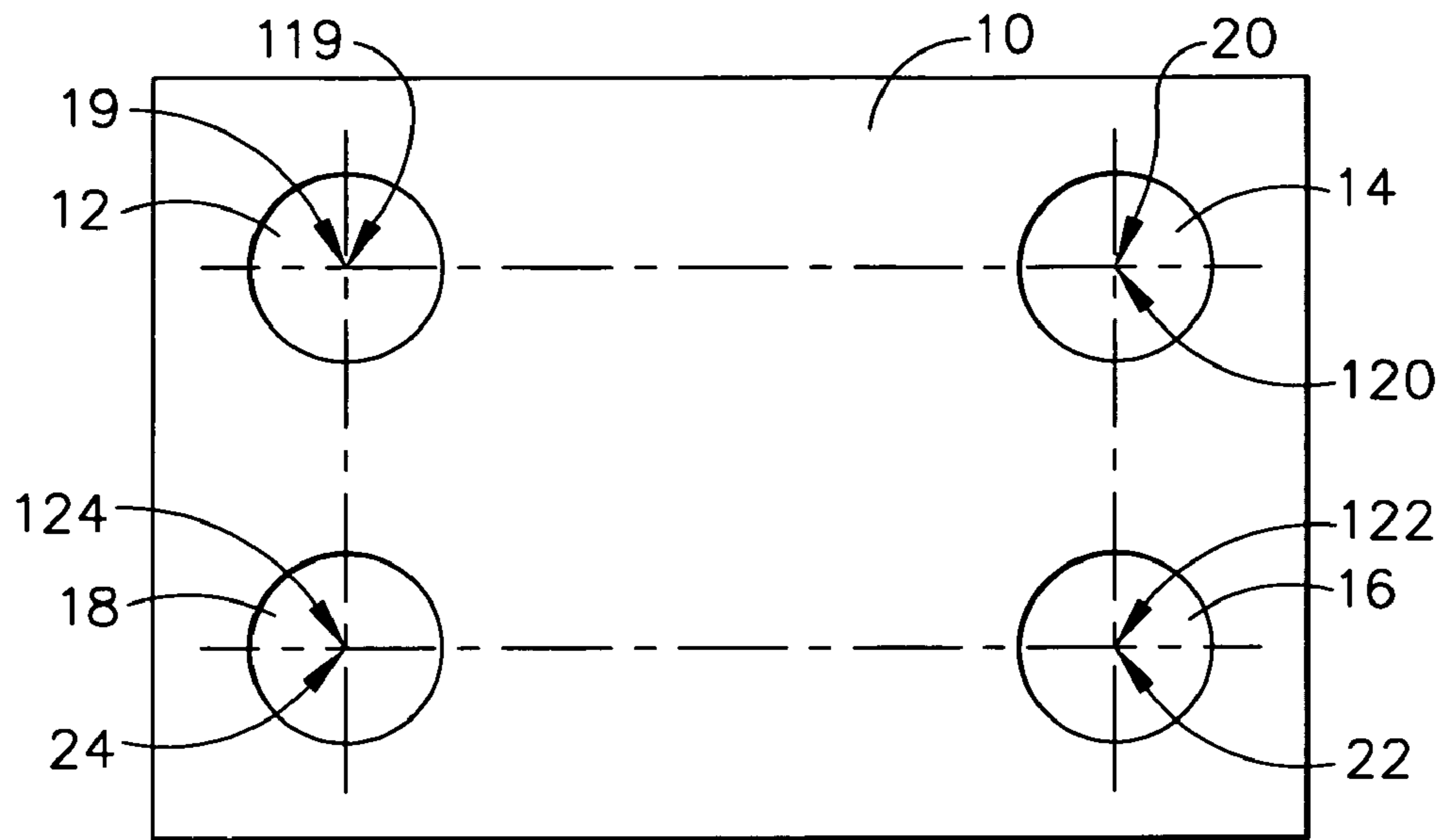


FIG. 2

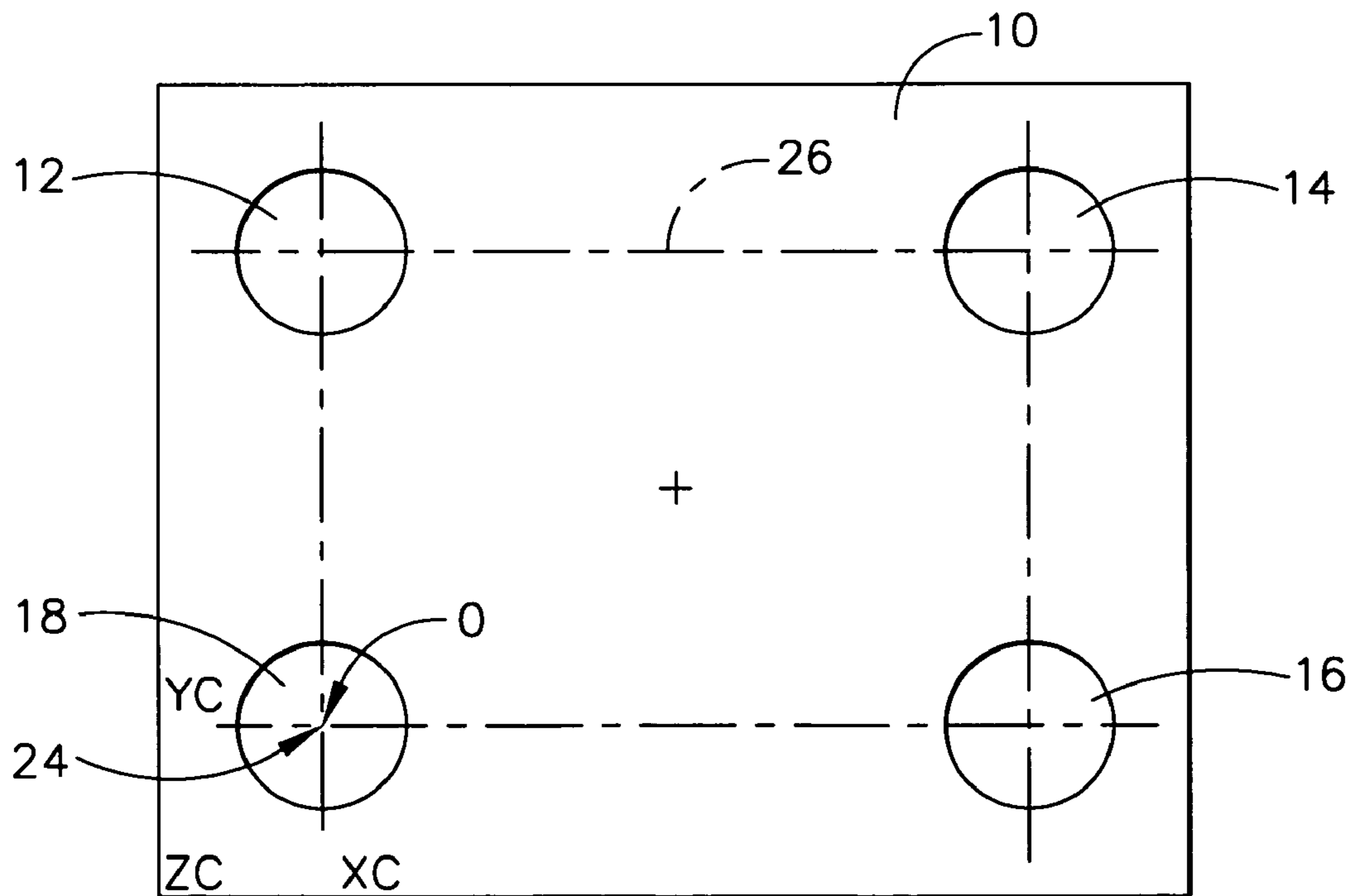


FIG. 3

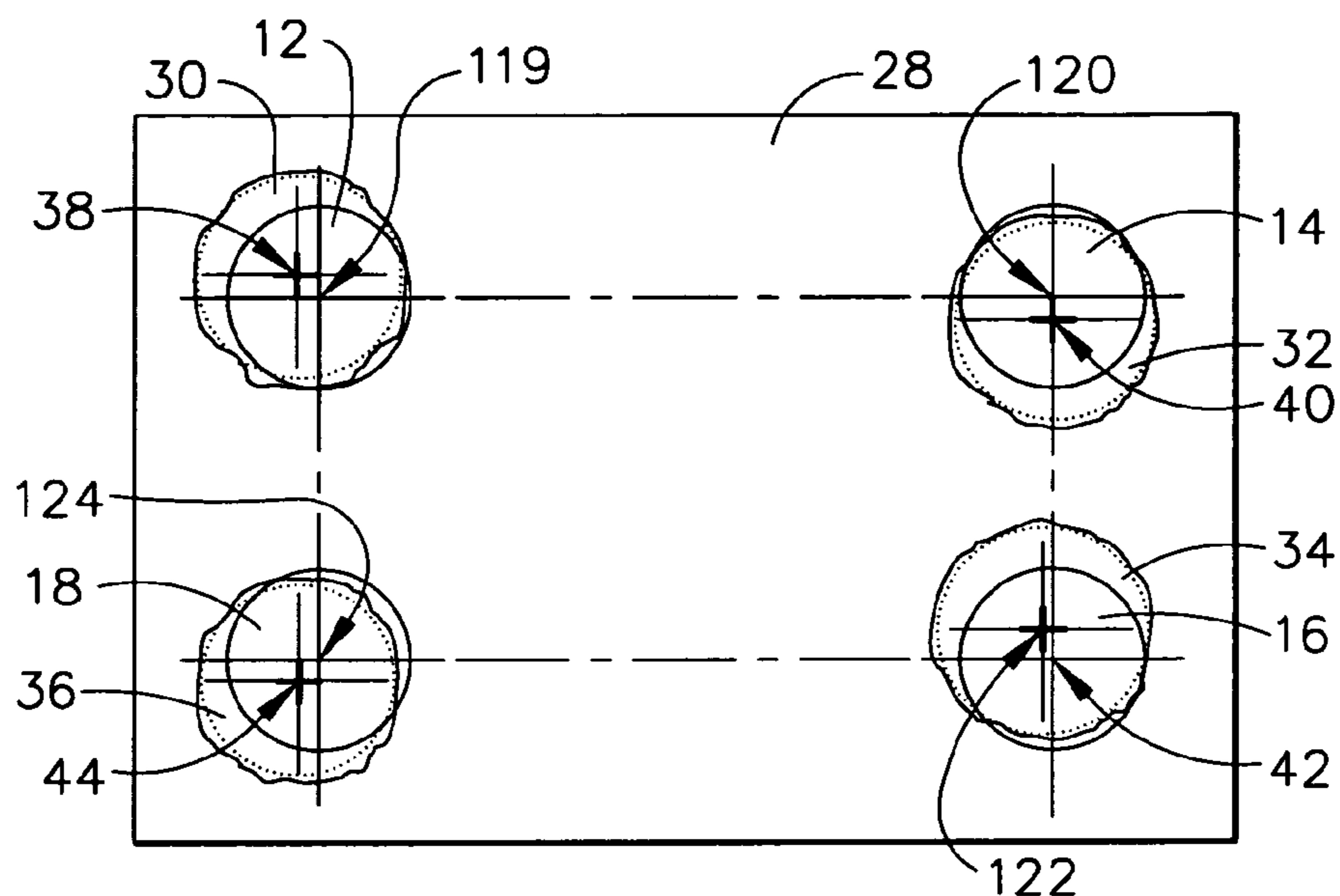


FIG. 4

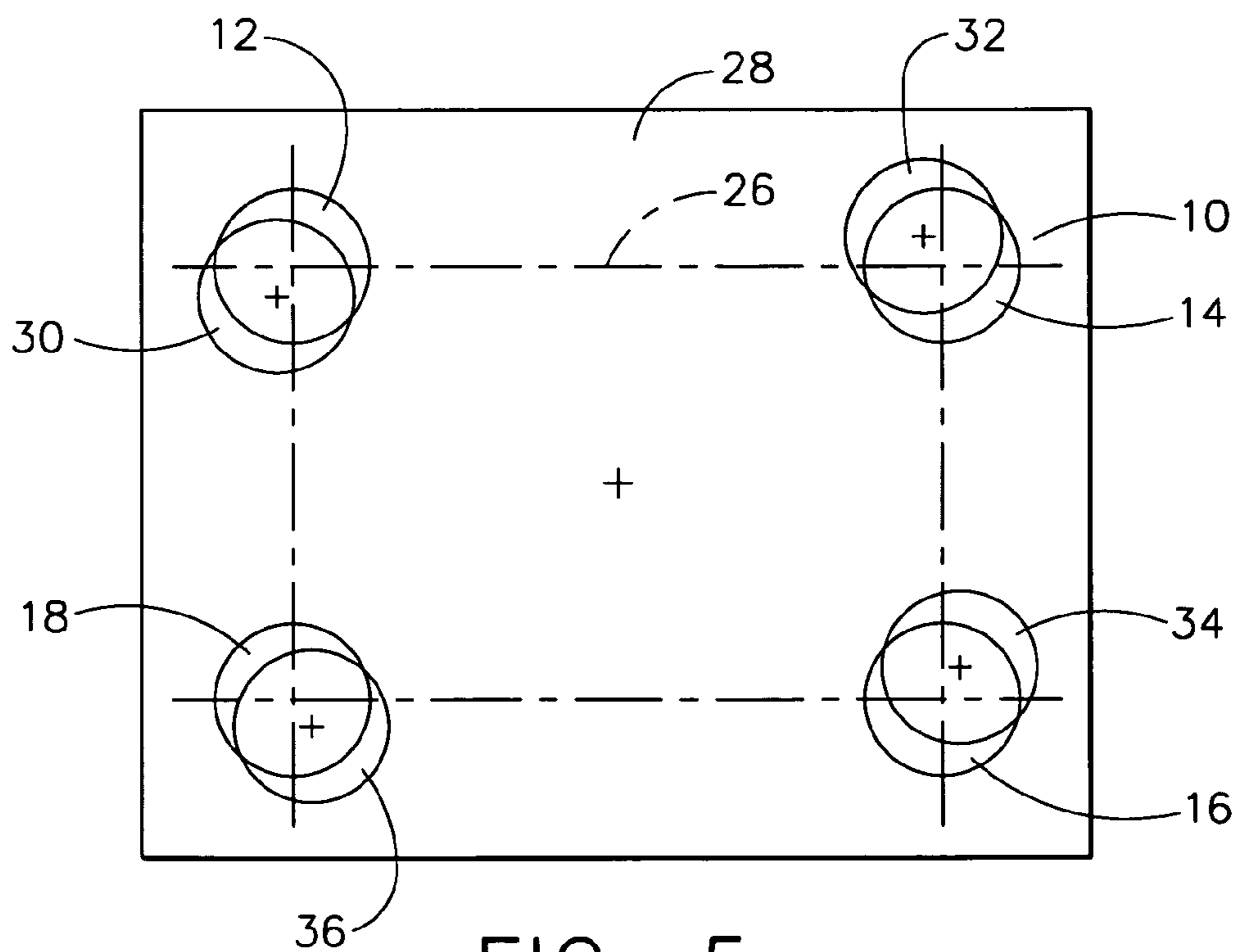


FIG. 5

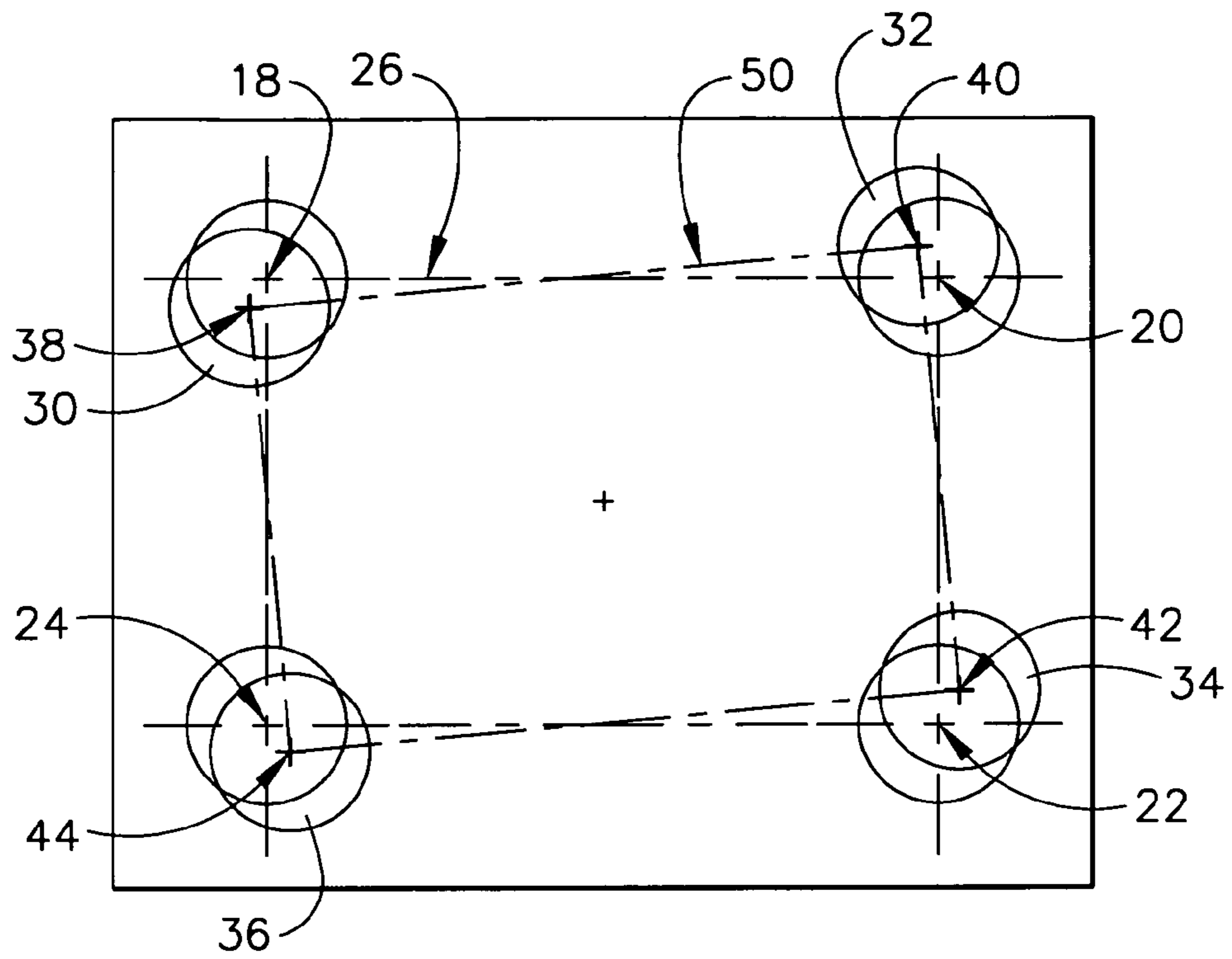


FIG. 6

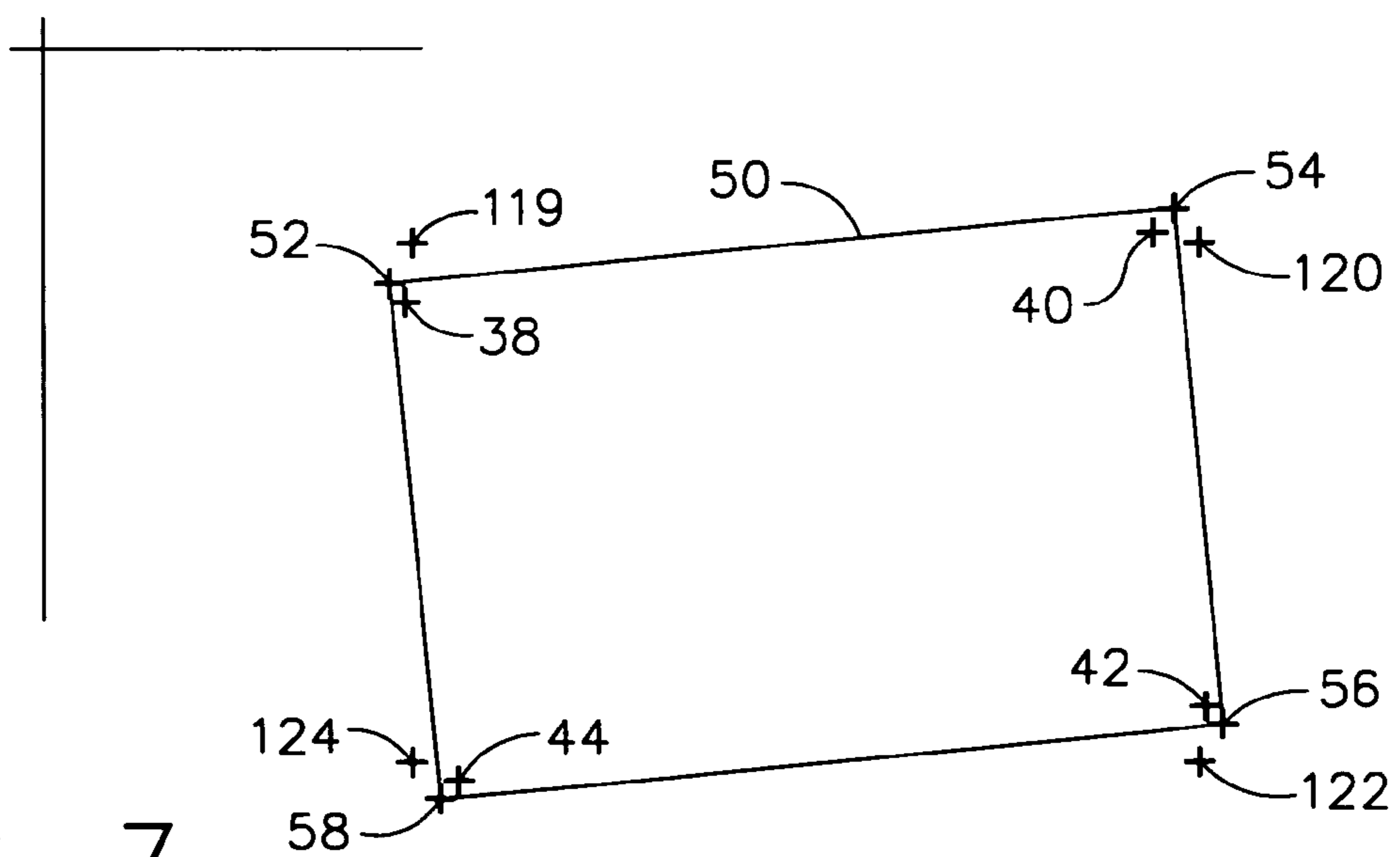


FIG. 7

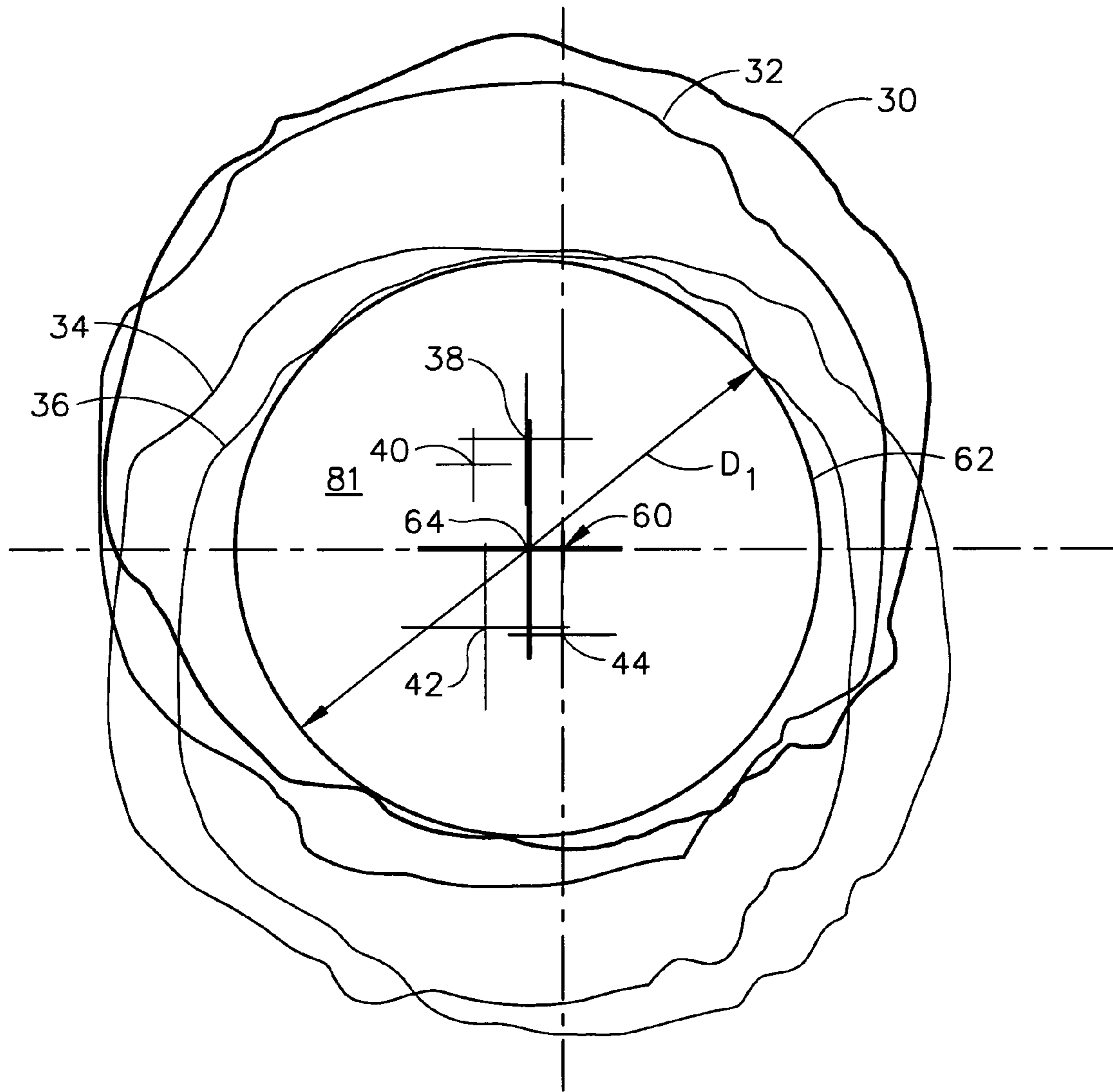


FIG. 8

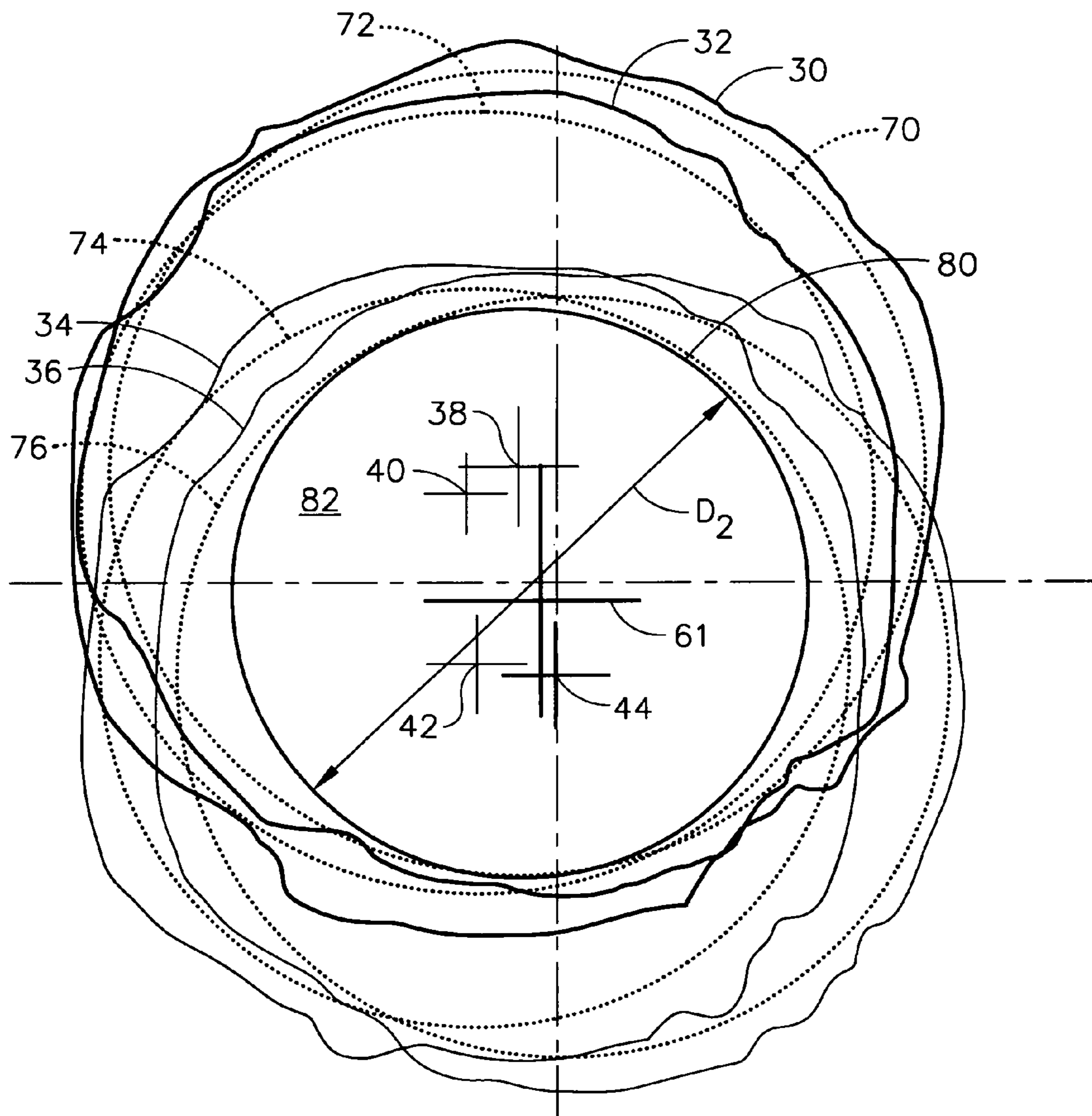


FIG. 9

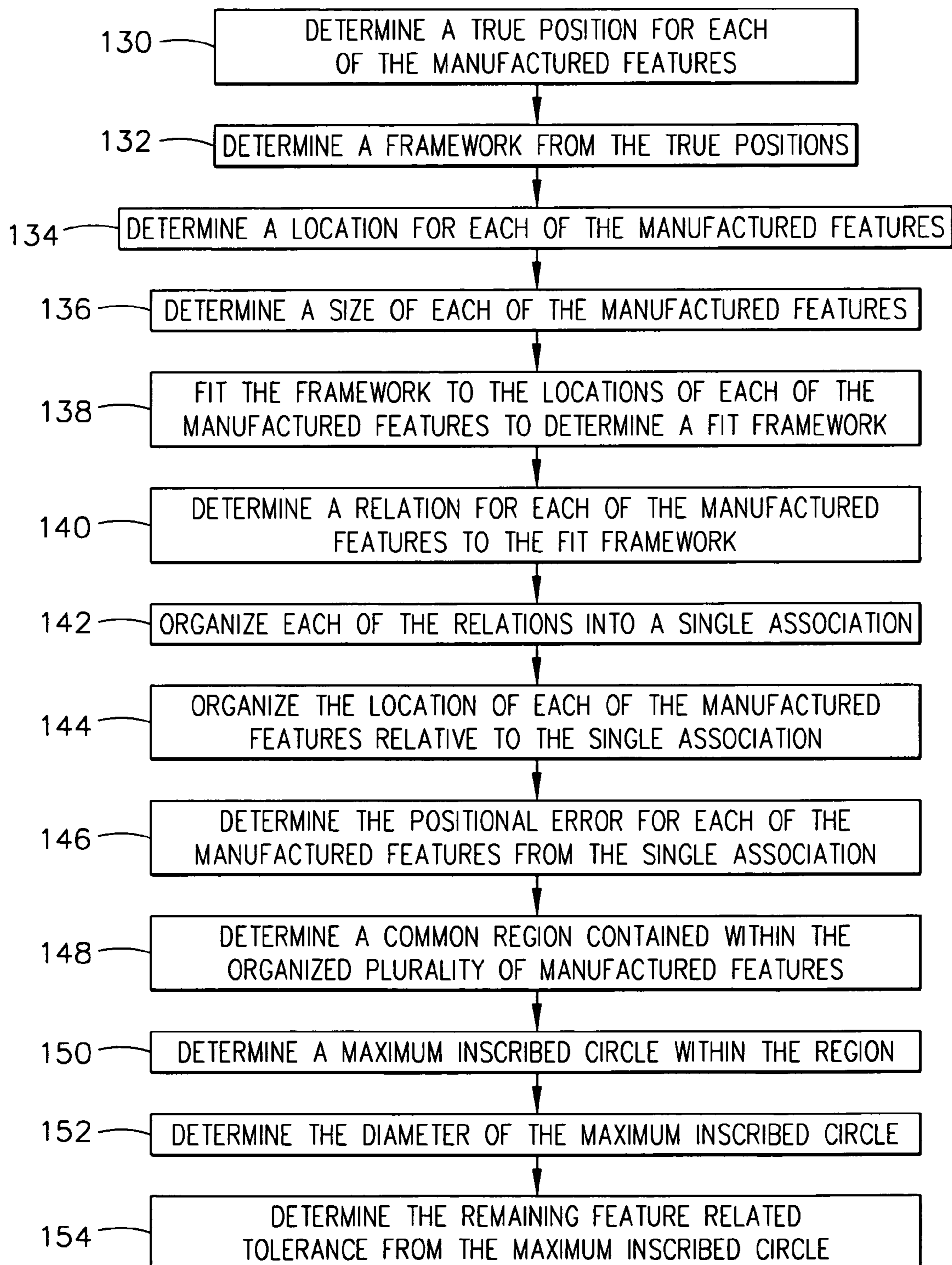


FIG. 10

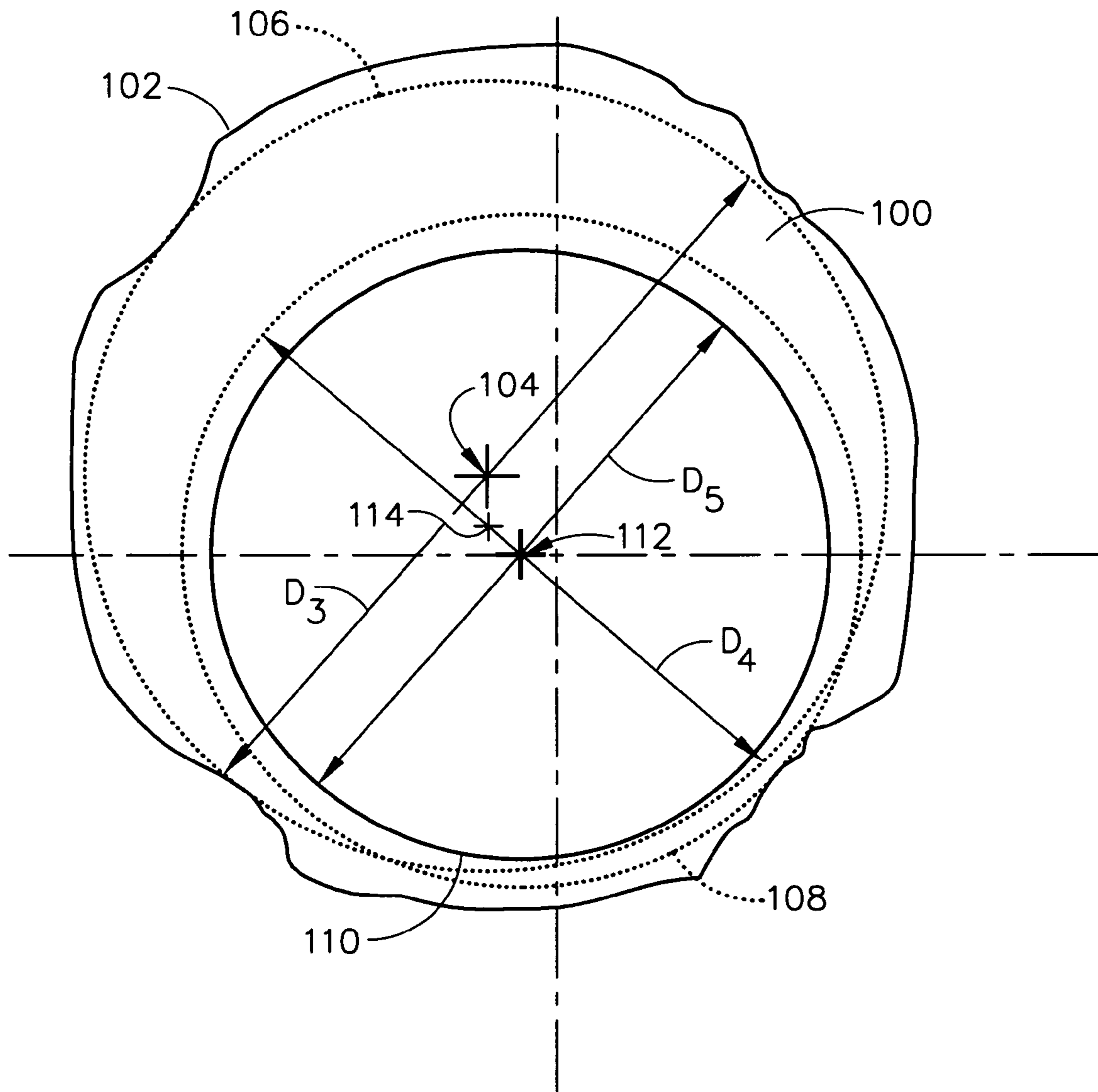


FIG. 11

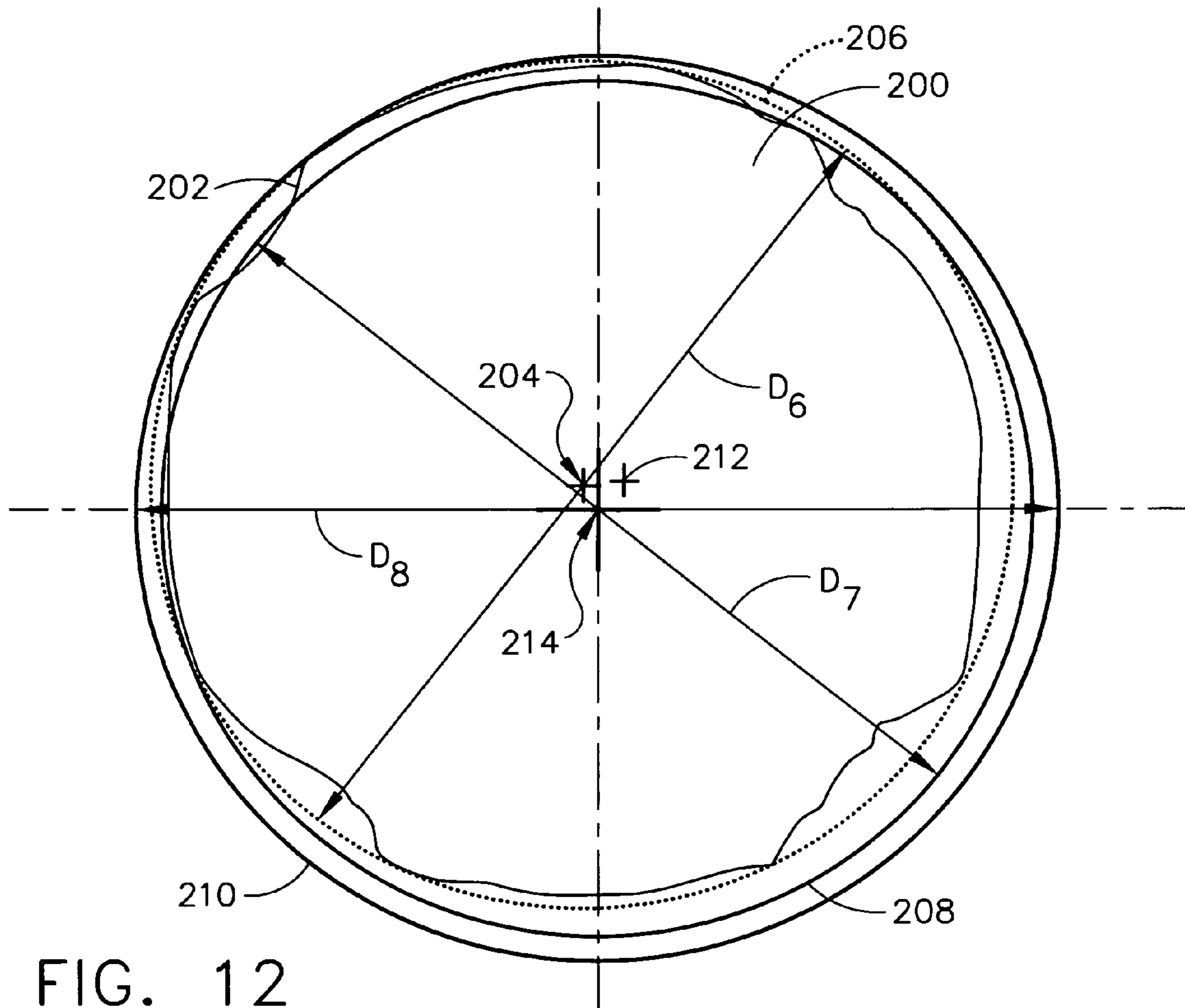


FIG. 12

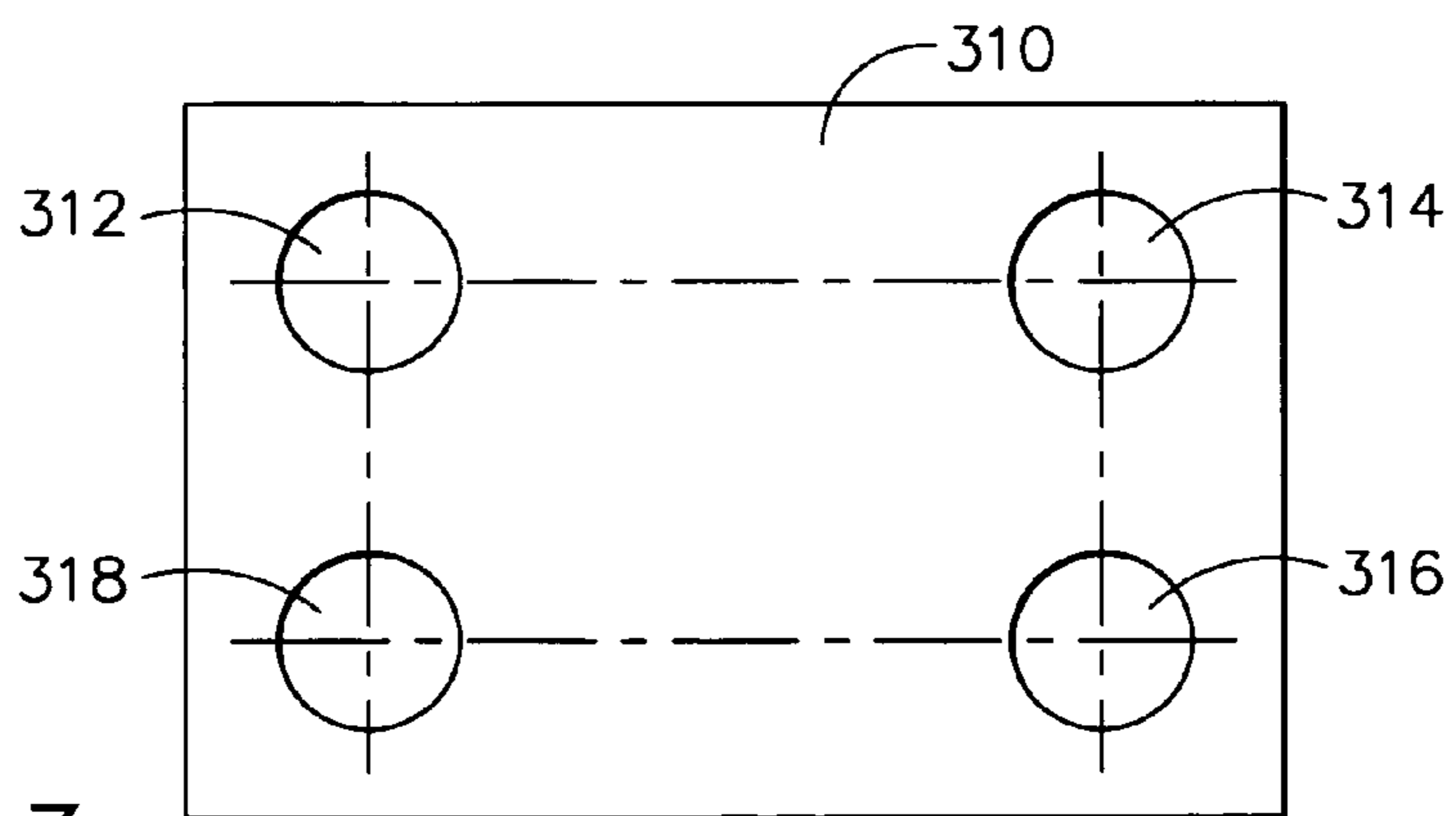


FIG. 13

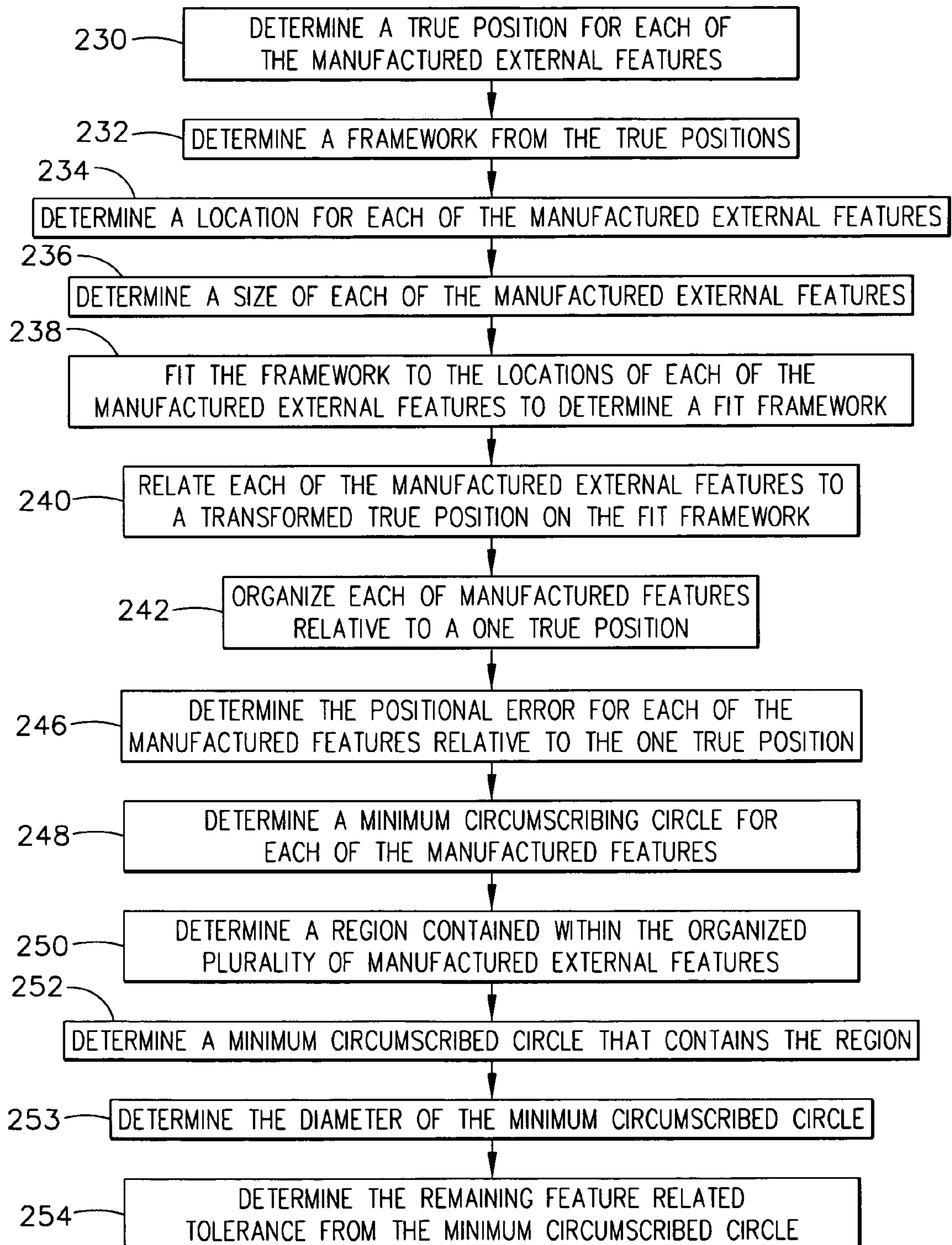


FIG. 14

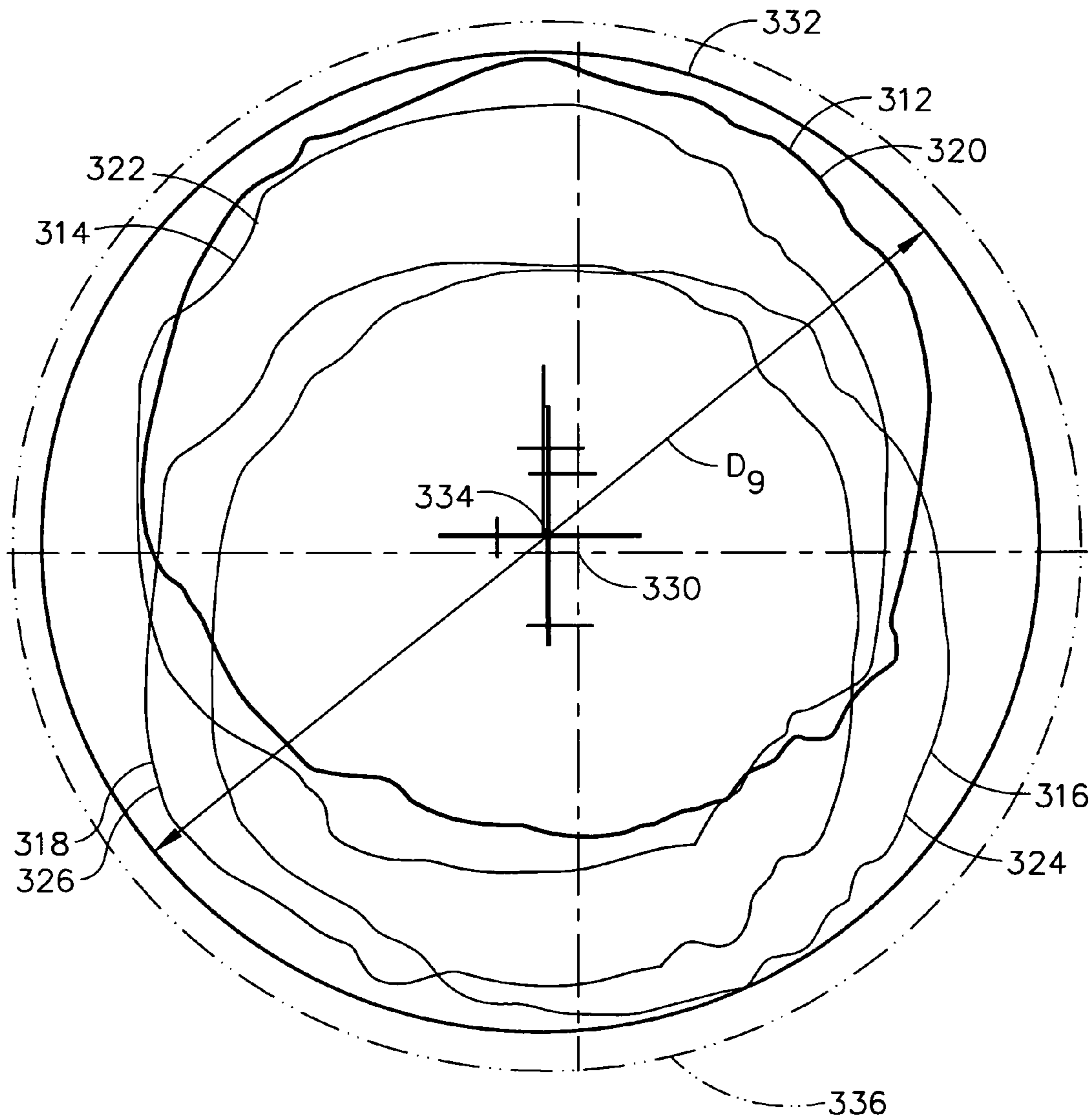


FIG. 15

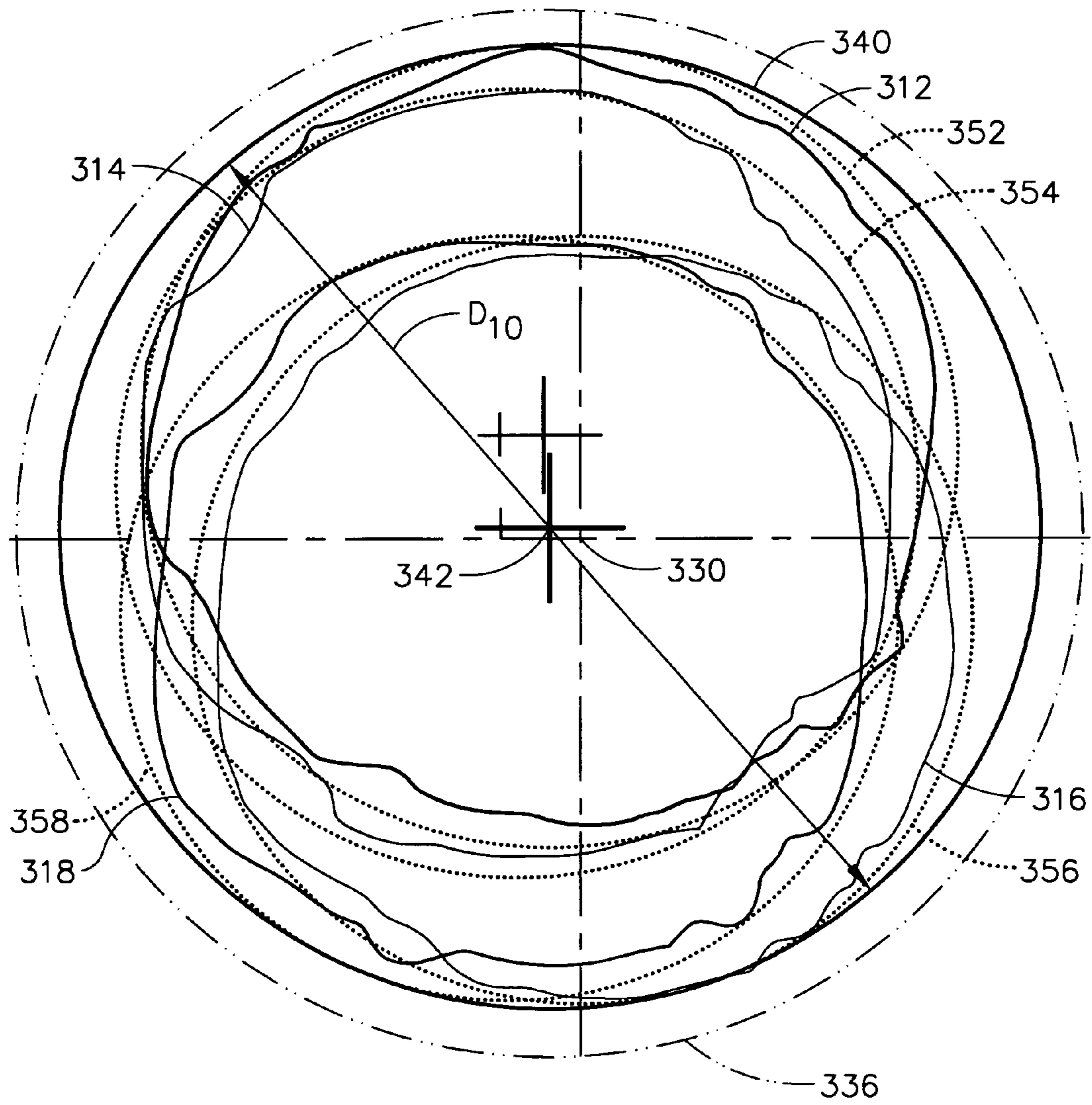


FIG. 16

COMBINED FEATURE DIMENSIONAL PARAMETER ANALYSIS

BACKGROUND OF THE INVENTION

The present invention generally relates to the production of articles of manufacture in a computer simulation or in the real world, and more particularly, to a method for accurately evaluating pattern compliance for a simulated or manufactured article.

American, Canadian, German, and International Organization for Standardization (ISO) standards define methods for specifying multiple levels of feature related tolerances. However, the manufacturing industry does not have an efficient or effective way of determining whether or not the requirements are achieved. Furthermore, there is no means for accurately assessing the effects of computer simulations with respect to feature relating tolerances. Inspection data of manufactured articles and varied feature data in simulations are not currently evaluated in an automated and correct manner to determine whether or not combined feature parameters such as hole size and location are acceptable to the applied feature relating tolerances. Evaluation of manufactured or simulated hole size, form, orientation, and location are all completed separately, and confidence in the accuracy of each evaluation is low.

Referring to FIG. 1, one method for documenting inspection data consists of paper gaging where information is recorded on paper. Measurements are taken, and errors are plotted on a grid **94** at an enlarged scale using a true position **96** as the origin. Hole positions **92** are then plotted on the grid **94**. Concentric circles **90** representing tolerance zone diameters are then overlain to determine positional errors. A problem with this method however, is that it is time consuming because it is not automated, nor is this method used with an automated process. Another problem is the difficulty of best fitting the concentric circles **90** into a position that encompasses all the hole positions **92** within the applicable concentric circle.

Another method for documenting inspection and simulation data uses variation analysis software that assesses feature related tolerances. Approximations and iterations are used that combine size, orientation, and location variations. Multiple iterations of inspecting feature size and positions are used to increase accuracy. However, using approximations reduces accuracy, and using multiple iterations causes excessive analysis time.

As can be seen, there is a need for accurately evaluating inspection and simulation data. Also, there is a need for evaluating inspection and simulation data in a timely manner, with perhaps, using only a single iteration. Moreover, there is a need for quickly analyzing inspection and simulation data in a step of the manufacturing process so that the results of the analysis can be used in subsequent processes.

Variation effects within a pattern of features may be determined when performing a variation analysis of a design prior to manufacturing that design. The variation analysis software performs hundreds or thousands of simulated build cycles, and in each cycle, varies all of the parameters randomly. Assembly variation analysis that utilizes feature patterns, such as holes, for assembly is currently reliant on approximations and iterations for the assembly of parts. Such a process may introduce error, is inefficient, and requires advanced software skills for completion.

In addition to the need for assessing produced parts, there is a need to accurately determine the variation effects on patterns of features during variation analysis.

SUMMARY OF THE INVENTION

In one aspect of the present invention, a machine-readable medium is provided for programming a computer to determine positional error and remaining feature related tolerance for a plurality of manufactured internal features on an object, the medium including processor executable instructions comprising determining a true position for each of the plurality of manufactured features, determining a framework from the true positions, determining a location for each of the plurality of manufactured features, determining a size of each of the plurality of manufactured features, fitting the framework to the locations of each of the plurality of manufactured features to determine a fit framework, determining the transformed relationship between the framework and the fit framework, determining a relation for each of the plurality of manufactured features to the fit framework, organizing each of the relations into a single association, organizing the location of each of the plurality of manufactured features relative to the single association, determining the positional error for each of manufactured features from the single association, determining a common region contained within the organized plurality of manufactured features, determining a maximum inscribed circle within the region, determining the diameter of the maximum inscribed circle, determining the center location of the maximum inscribed circle, determining the transformation of the center location of the maximum inscribed circle from the single association, and determining the remaining feature related tolerance from the maximum inscribed circle.

In another aspect of the present invention, a machine-readable medium is provided for programming a computer to determine positional error and remaining hole related tolerance for a plurality of manufactured holes on an object, the medium including processor executable instructions comprising determining a true position for each of the plurality of manufactured holes, determining a feature related tolerance zone framework (FRTZF) from the true positions, determining a center for each of the plurality of manufactured holes, determining a size of each of the plurality of manufactured holes, fitting the FRTZF to the centers of the plurality of manufactured holes to determine a best fit framework, determining a transformed true position for each of the plurality of manufactured holes, superimposing each of the transformed true positions to form one true position, determining the location of each of the plurality of manufactured holes relative to the one true position, determining a common region contained within the manufactured holes represented about the one true position, determining a first maximum inscribed circle within the common region, determining the diameter of the first maximum inscribed circle, determining a center location of the first maximum inscribed circle, and determining the remaining hole related tolerance from the maximum inscribed circle.

In another aspect of the present invention, a machine-readable medium is provided for programming a computer to evaluate compliance of a single internal feature in a pattern on an object, to the virtual condition, the medium including processor executable instructions comprising providing a pattern of features, acquiring dimensions and location of a manufactured internal feature, determining a maximum inscribed circle for a pattern of features, providing a virtual condition, and determining if there is clearance between the maximum inscribed circle and the virtual condition.

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In another aspect of the present invention, a machine-readable medium is provided for programming a computer to determine positional error for a plurality of manufactured holes on an object, the medium including processor executable instructions comprising determining a true position for each of the plurality of manufactured holes, determining a framework from the true positions, determining a center for each of the plurality of manufactured holes, fitting the framework to the centers of the plurality of manufactured holes to determine a best fit framework, determining a transformed true position for each of the plurality of manufactured holes, determining a one true position from the transformed true positions, determining the location of each of the plurality of manufactured holes relative to the one true position, determining a common region contained within the manufactured holes represented about the one true position, determining a first maximum inscribed circle within the common region, determining the center of the first maximum inscribed circle, and determining the location of the center of the first maximum inscribed circle relative to the one true position.

In another aspect of the present invention, a method for determining positional error and remaining feature related tolerance for a plurality of manufactured internal features on an object comprises determining a true position for each of the plurality of manufactured features, determining a framework from the true positions, determining a location for each of the plurality of manufactured features, determining a size of each of the plurality of manufactured features, fitting the framework to the locations of each of the plurality of manufactured features to determine a fit framework, determining a relation for each of the plurality of manufactured features to the fit framework, organizing each of the relations into a single association, organizing the location of each of the plurality of manufactured features relative to the single association, determining the positional error for each of manufactured features from the single association, determining a common region contained within the organized plurality of manufactured features, determining a maximum inscribed circle within the region, determining the diameter of the maximum inscribed circle, and determining the remaining feature related tolerance from the maximum inscribed circle.

In another aspect of the present invention, a machine-readable medium is provided for programming a computer to determine positional error and remaining feature relating tolerance for a plurality of manufactured external features, the medium including processor executable instructions comprising determining a true position for each of the plurality of manufactured external features, determining a feature relating tolerance zone framework (FRTZF) from the true positions, determining a center for each of the plurality of manufactured external features, determining a size of each of the plurality of manufactured external features, fitting the FRTZF to the centers of the plurality of manufactured external features to determine a best fit framework, determining a transformed true position for each of the plurality of manufactured external features, superimposing each of the transformed true positions to form a one true position, determining the location of each of the plurality of manufactured external features relative to the one true position, determining a region contained within the manufactured external features represented about the one true position, determining a first minimum circumscribing circle about the region, determining the diameter of the first

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minimum circumscribing circle, and determining the remaining feature related tolerance from the minimum circumscribing circle.

In another aspect of the present invention, a machine-readable medium is provided for programming a computer to evaluate compliance of a single external feature in a pattern on an object, to the virtual condition, the medium including processor executable instructions comprising providing a pattern of external features, acquiring dimensions and location of a manufactured external feature, determining a minimum circumscribing circle for a pattern of features, providing a virtual condition, and determining if there is interference between the minimum circumscribing circle and the virtual condition.

In another aspect of the present invention, a method for determining positional error and remaining feature relating tolerance for a plurality of manufactured holes on an object comprises determining a true position for each of the plurality of manufactured features, determining a framework from the true positions, determining a location for each of the plurality of holes, determining a size of each of the plurality of holes, fitting the framework to the locations of each of the plurality of holes to determine a fit framework, determining a relation for each of the plurality of holes to the fit framework, organizing each of the relations into a single association, organizing the location of each of the plurality of holes relative to the single association, determining the positional error for each of holes from the single association, determining a common region contained within the organized plurality of holes, determining a maximum inscribed circle within the region, determining the diameter of the maximum inscribed circle, and determining the remaining feature related tolerance from the maximum inscribed circle.

In another aspect of the present invention, a method for determining positional error and remaining feature relating tolerance for a plurality of manufactured external features on an object comprises determining a true position for each of the plurality of manufactured external features, determining a framework from the true positions, determining a location for each of the plurality of manufactured external features, determining a size of each of the plurality of manufactured external features, fitting the framework to the locations of each of the plurality of manufactured external features to determine a fit framework, determining a transformed true position for each of the plurality of manufactured features to the fit framework, organizing each of the transformed true positions into a one true position, organizing the location of each of the plurality of manufactured external features relative to the one true position, determining the positional error for each of manufactured external features from the single association, determining a region encompassed by the organized plurality of manufactured external features, determining a minimum circumscribing circle about the region, determining the diameter of the minimum circumscribing circle, and determining the remaining feature related tolerance from the minimum circumscribing circle.

These and other features, aspects and advantages of the present invention will become better understood with reference to the following drawings, description and claims.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a diagram illustrating a prior art paper gaging technique for documenting inspection data;

FIG. 2 is a diagram illustrating the designed features for a rectangular plate having four holes, according to an embodiment of the present invention;

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FIG. 3 is a diagram illustrating the feature related tolerance zone framework (FRTZF) for the rectangular plate in FIG. 2, according to an embodiment of the present invention;

FIG. 4 is a diagram illustrating a manufactured rectangular plate, according to an embodiment of the present invention;

FIG. 5 is a diagram illustrating the designed pattern for a rectangular plate and manufactured holes, according to an embodiment of the present invention;

FIG. 6 is a diagram illustrating the positional errors and true positions of each manufactured hole relative to a best fit framework, according to an embodiment of the present invention;

FIG. 7 is a diagram illustrating the true positions and the centers of each manufactured hole relative to a best fit framework, according to an embodiment of the present invention;

FIG. 8 is a diagram illustrating a one true position and manufactured holes relative to the one true position, according to an embodiment of the present invention;

FIG. 9 is a diagram illustrating inscribed circles, manufactured holes and a one true position, according to an embodiment of the present invention;

FIG. 10 is a flowchart illustrating a method for determining the positional error and remaining feature related tolerance for a pattern of internal features on an object, according to an embodiment of the present invention;

FIG. 11 is a diagram illustrating an internal feature and a virtual condition, according to an embodiment of the present invention;

FIG. 12 is diagram illustrating an external feature and a virtual condition, according to an embodiment of the present invention;

FIG. 13 is a diagram illustrating the designed features for a rectangular plate having four pins, according to an embodiment of the present invention;

FIG. 14 is a flowchart illustrating a method for determining the positional error and remaining feature related tolerance for a pattern of external features on an object, according to an embodiment of the present invention;

FIG. 15 is a diagram illustrating manufactured external features and a one true position, according to an embodiment of the present invention; and

FIG. 16 is a diagram illustrating manufactured external features, circumscribing circles, and a one true position, according to an embodiment of the present invention.

DETAILED DESCRIPTION OF THE INVENTION

The following detailed description is of the best currently contemplated modes of carrying out the invention. The description is not to be taken in a limiting sense, but is made merely for the purpose of illustrating the general principles of the invention, since the scope of the invention is best defined by the appended claims. References to manufactured features may equally refer to features generated in a computer simulation or features produced in fabrication processes.

The present invention provides a method for determining the size and location of manufactured features on an object, determining the translation of a pattern of features, determining tolerances consumed, and determining remaining feature tolerances. Such method may be, but not limited to, hand-implemented or implemented by a computer program. By determining remaining feature tolerances for features

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such as holes during or shortly after a manufacturing process, it is possible to determine how the features will interact with patterns of features on other parts. Furthermore, the data collected from each analysis of a part may be used to determine algorithms to predict future remaining feature tolerances. In an embodiment, the method may be a program implemented by a computer. The program may be distributed by, but not limited to, a machine-readable medium such as a floppy disk or a compact disk. The program may also be hardware implemented. Unlike previous methods, the present invention may acquire and assess feature sizes and feature patterns with a single iteration. Also, the present invention may acquire and utilize inspection data accurately using many methods known in the art, including, but not limited to, a coordinate measuring machine rather than paper gaging the inspection data.

The present invention provides a method for determining the size and location of simulated or manufactured features on an object, determining the transformation of a pattern of features, and determining remaining feature tolerances. Such method may be, but is not limited to being, hand-implemented or implemented by a computer program. By determining remaining feature tolerances in a simulation, design requirements can be established for mating parts and the assembly freedom between parts can be predicted. By determining remaining feature tolerances for features such as holes during or shortly after a manufacturing process, quality of assembly with other parts can be determined in advance of assembly. Furthermore, the data collected from each analysis of a part may be used to determine algorithms to predict future remaining feature tolerances. In an embodiment, the method may be a program implemented by a computer. The program may be distributed by, but not limited to, a machine-readable medium such as a floppy disk or a compact disk. The program may also be hardware implemented. Unlike previous methods, the present invention may acquire feature sizes and feature patterns with a single iteration. Also, the present invention may acquire inspection data accurately using a coordinate measuring machine rather than paper gaging the inspection data.

In an embodiment, FIG. 2 is a diagram illustrating the designed internal features for an object such as a part. The designed part is a rectangular plate 10 having features including four spaced-apart circular holes 12, 14, 16, 18. While circular holes are used to illustrate the present invention, a feature may also be, but not limited to, polygonal and oval. Each of the designed circular holes 12, 14, 16, 18 has a center, referred to as the true center 19, 20, 22, 24, respectively, and a designed size, referred to as a true size. Each hole 12, 14, 16, 18 may have a designed position on the rectangular plate referred to as a true position. Multiple points on a feature may be used to track the position of a feature between the feature's designed position and the feature's manufactured position. For example, for a rectangular hole, points on the surface of the sides and at the corners may be used or the center of the rectangle may be used. For a circular hole, the center of the hole may be used. The true centers 19, 20, 22, 24 may be used as the true position 119, 120, 122, 124 for each hole 12, 14, 16, 18, respectively. A computer aided drafting (CAD) system may be used to render the diagram. The information of the circular holes 12, 14, 16, and 18 may be represented as digital data and stored on a machine-readable medium including a hard drive and an optical disk, as well as being processed on a computer.

FIG. 3 is a diagram illustrating the feature related tolerance zone framework (FRTZF) 26 for the rectangular plate

10 in FIG. 2. An FRTZF provides relational information that accounts for the tolerances of each feature, and the relation between the tolerances of each feature in relation to a whole pattern of features. For example, a four-pin plate having four pins is to be mated to the rectangular plate **10**, whereby the four pins are to be inserted into holes **12, 14, 16, 18**. An FRTZF for the rectangular plate **10** would provide the maximum tolerances that if exceeded, the four-pin plate could no longer mate with the rectangular plate. An xyz coordinate system for the FRTZF may use the center **24** of the bottom left circle **18** as the origin **0**, and the true positions **119, 120, 122** of the other circles **12, 14, 16** as reference points (FIG. 2).

FIG. 4 is a diagram illustrating a real-world manufactured rectangular plate **28**, created from the design illustrated in FIG. 2. The manufactured holes **30, 32, 34, and 36** correspond to designed holes **12, 14, 16 and 18**. Manufactured rectangular plate **28** may also represent a simulated manufactured plate, and manufactured holes **30, 32, 34, and 36** may represent simulated manufactured holes. The simulated holes may be generated to provide a variation analysis model of a rectangular plate. Manufactured holes **30, 32, 34, and 36** may include variation from the true size and location. Designed holes **12, 14, 16 and 18** define where manufacture holes **30, 32, 34, and 36** are supposed to be. Each manufactured hole **30, 32, 34, 36** has deviated from the true size as well as the true position. A true size deviation may comprise a hole larger than designed, a hole smaller than designed, and a hole having inner surface roughness. Each hole may have a positional error relative to its true position. The positional error may be determined by the distance between center **38, 40, 42, 44** of each manufactured hole **30, 32, 34, 36** and their true positions **119, 120, 122, 124**, respectively. The deviations may extend along the depth of each hole. Data regarding the dimensions and position of the manufactured rectangular plate **28** may be acquired by many methods known in the art, including, but not limited to, examining the rectangular plate **10** with a device such as a coordinate measuring machine.

FIG. 5 is a diagram of the holes **30, 32, 34, 36** of the manufactured rectangular plate **28** from FIG. 4, superimposed over the designed pattern of the rectangular plate **10** shown in FIG. 2. The manufactured holes **30, 32, 34, 36** have positional errors and true size deviations relative to the designed pattern of the rectangular plate **10**.

FIG. 6 is a diagram illustrating the positional errors of each manufactured hole **30, 32, 34, 36** and the true positions **18, 20, 22, 24** of each hole, relative to a best fit tolerance zone framework (best fit framework) **50**. The FRTZF **26** may be best fit to the manufactured holes **30, 32, 34, 36** by best fitting the true positions **18, 20, 22, 24** to the centers **38, 40, 42, 44** of the manufactured holes **30, 32, 34, 36**, while retaining the structure of the FRTZF **26**. Examples of best fit methods are well known in the art and may include, but are not limited to, a least squares or total least squares method. The best fit of the FRTZF **26** may cause the FRTZF **26** to translate and/or rotate relative to the FRTZF's original position, resulting in a best fit framework **50**. Comparing the best fit framework **50** with the FRTZF **26** indicates how much the pattern of the features of the rectangular plate **10** has transformed, i.e. translated and rotated. The translation and rotation of a pattern of features may be evaluated relative to an origin located at, but not limited to, a true position of a circle, an edge of the manufactured part, a corner of a manufactured part, and a location on a part to be mated with the manufactured part.

FIG. 7 is a diagram illustrating the true positions **119, 120, 122, 124** of each hole and the centers **38, 40, 42, 44** of each manufactured hole relative to the best fit framework **50**. The best fit framework **50** establishes transformed true positions for each circle, where each transformed true position **52, 54, 56, 58** represents a true position **18, 20, 22, 24**, respectively, that has rotated and translated with the FRTZF **26** (FIG. 6) when producing the best fit framework **50**.

FIG. 8 is a diagram illustrating an embodiment using the surfaces of holes using one true position and the manufactured holes **30, 32, 34, 36**, relative to the one true position **60**. The one true position **60** is a single association determined by superimposing each of the transformed true positions **52, 54, 56, 58** (FIG. 7) of the best fit framework **50** onto each other. The produced or simulated surfaces of the holes **30, 32, 34, 36** and centers **38, 40, 42, 44** of each manufactured hole **30, 32, 34, 36**, respectively, are organized relative to the one true position **60**. The dimensions of holes **30, 32, 34 and 36** may be determined by selecting a multitude of surface points on each hole **30, 32, 34, 36**. The center of the manufactured hole, simulated or not simulated, may be established first. A circle **62** having the largest possible diameter is inscribed within the area **81** defined within all of the manufactured holes **30, 32, 34, 36**. The center **64** of the inscribed circle **62** is compared to the one true position **60** of the circle **62** to determine the amount of translation of the pattern of features relative to the best fit framework **50** (FIG. 7). The difference between the diameter D_1 of the inscribed circle **62** and the virtual condition equals the remaining allowable feature relating tolerance for the pattern of holes as a group. The virtual condition is a constant boundary generated by the collective effects of a feature's specified (maximum material condition) MMC or least material condition (LMC) and the specified geometric tolerance for that material condition. For a hole, the virtual condition is equal to the MMC (the smallest size that the hole may be) minus the positional tolerance for that hole. MMC may be defined as the condition in which a feature of size contains the maximum amount of material within the stated limits of size—for example, the minimum hole diameter for a hole. LMC may be defined as the condition in which a feature of size contains the least amount of material within the stated limits of size, for example, maximum hole diameter for a hole.

FIG. 9 is a diagram illustrating an embodiment using inscribed circles **70, 72, 74, 76** for each manufactured hole **30, 32, 34, 36** to find a one true position **61**. Similar to the procedure illustrated in FIG. 8, the one true position **60** is determined by superimposing each of the transformed true positions **52, 54, 56, 58** of the best fit framework **50** onto each other (FIG. 7). The surfaces for each of the manufactured holes **30, 32, 34, 36** is represented relative to the true center **60**. A circle **70, 72, 74, 76** having the largest possible diameter is inscribed within each of the manufactured holes **30, 32, 34, 36**, respectively. Centers **38, 40, 42, 44** of the produced holes **30, 32, 34, 36** are located at the centers of circles **70, 72, 74, 76**. A circle **80** having a maximum diameter is then inscribed within the area **82** defined by inscribed circles **70, 72, 74, and 76**. The center **61** of inscribed circle **80** is compared to the one true position **60** (FIG. 8) to determine the amount of translation of the pattern of features relative to the best fit framework **50**. The difference between the diameter D_2 of inscribed circle **80** and the virtual condition equals the remaining allowable feature relating tolerance.

FIG. 10 is a flowchart illustrating an embodiment of a method for determining the positional error and remaining

feature related tolerance for a pattern of internal features on an object. Positional error and remaining feature related tolerance for a pattern of internal features may be determined by a step of determining **130** a true position for each of the manufactured features. An example of step **130** may be found in the description of FIG. **3**. Another step of determining positional error and remaining feature related tolerance for a pattern of internal features may include a step of determining **132** a framework from the true positions. An example of step **132** may be found in the description of FIG. **4**. Another step may include a step of determining **134** a location for each of the manufactured features. An example of step **134** may be found in the description of FIG. **4**. Another step may include a step of determining **136** a size of each of the manufactured features. An example of step **136** may be found in the description of FIG. **4**. Another step of determining positional error and remaining feature related tolerance for a pattern of internal features may include a step of fitting **138** the framework to the locations of each of the manufactured features to determine a fit framework. An example of step **138** may be found in the description of FIG. **6**.

Still referring to FIG. **10**, another step of determining positional error and remaining feature related tolerance for a pattern of internal features may include a step of determining **140** a relation for each of the manufactured features to the fit framework. An example of step **140** may be found in the description of FIG. **6**. Another step may include a step of organizing **142** each of the relations into a single association. An example of step **142** may be found in the description of FIG. **8**. Another step may include a step of organizing **144** the location of each of the manufactured features relative to the single association. An example of step **144** may be found in the description of FIG. **8**. Another step may include a step of determining **146** the positional error for each of the manufactured features from the single association. An example of step **146** may be found in the description of FIG. **8**. Another step may include a step of determining **148** a common region contained within the organized plurality of manufactured features. An example of step **148** may be found in the description of FIG. **8**. Another step may include a step of determining **150** a maximum inscribed circle within the region. An example of step **150** may be found in the description of FIG. **8**. Another step may include a step of determining **152** the diameter of the maximum inscribed circle. An example of step **152** may be found in the description of FIG. **8**. And, another step may include a step of determining **154** the remaining feature related tolerance from the maximum inscribed circle. An example of step **154** may be found in the description of FIG. **8**.

FIG. **11** is a diagram illustrating one embodiment where an internal feature such as a hole **100** is evaluated on an individual basis to determine if the feature violates the virtual condition of the feature relating tolerance, and if so, how the feature may be modified. The hole **100** has a feature surface **102** and a feature center **104**. A circle **106** may be inscribed within hole **100** having the maximum possible diameter. A virtual condition circle **108** representing the virtual condition may be drawn with a center **112** located at the same center as for the maximum inscribed circle **110** for the pattern. A maximum inscribed circle for the pattern **110** may also be represented. A maximum inscribed circle for the pattern **110** is a circle for the hole **100** that fits in the feature pattern. The feature pattern translation is determined by calculating the positional difference between the maximum inscribed circle center **112** and the center **114** of inscribed

circle **106** for the hole **100**. Inscribing diameter D_3 represents the usable diameter of the hole **100** for a single fastener or mating part to be inserted within the hole **100**. Diameter D_5 represents the usable diameter of the pattern of holes in the part.

Still referring to FIG. **11**, the maximum inscribed circle **110** for the pattern is smaller than the virtual condition circle **108**, and thus one or more features violate the tolerance requirements of the virtual condition, resulting in interference between the hole and another object such as a fastener or mating part. If the maximum inscribed circle **110** for the pattern is larger than the virtual condition circle **108**, there is clearance between the hole and another object such as a fastener or mating part. Feature violations may include, but are not limited to, feature size, pattern translation and feature translation relative to the pattern. The combined total of all the feature violations is the difference between the diameter D_5 of the maximum inscribed circle for the pattern **110** and the diameter D_4 of the virtual condition circle **108**. Feature size and location may be altered to eliminate violations of the virtual condition. Feature size for the hole may be altered by first determining the difference between the minimum tangent radius from center **112** to circle **106** and the virtual condition radius. The hole location may be altered along a vector between the hole center **104** and the virtual condition center **112**.

FIG. **12** is a diagram illustrating an embodiment where an external feature such as a pin **200** is evaluated on an individual basis to determine if the feature violates the virtual condition, and if so, how the feature may be modified. The pin **200** has a feature surface **202** and a feature center **204**. A circle **206** may be circumscribed about pin **200** having the minimum possible diameter. A virtual condition circle **208** representing the virtual condition may be drawn relative to the pin **200**. A minimum circumscribing circle for the pattern **210** may also be represented. A minimum circumscribing circle for the pattern **210** is a circle for the pin **200** that fits in the feature pattern. The feature pattern translation is determined by calculating the positional difference between the true position **212** and the center **214** of circumscribing circle **206** for the pin **200**. The diameter D_6 of the minimum circumscribing circle **206** represents the effective diameter of the pin **200** when inserted within a hole.

Still referring to FIG. **12**, the minimum circumscribing circle **210** for the pattern is larger than the virtual condition circle **208**, and thus one or more features violate the tolerance requirements of the virtual condition, resulting in interference between the pin **200** and the hole into which the pin **200** will be inserted. Feature violations may include, but are not limited to, feature size, pattern translation and feature translation relative to the pattern. The combined total of all the feature violations is the difference between the diameter D_8 of the minimum circumscribing circle for the pattern **210** and the diameter D_7 of the virtual condition circle **208**. Feature size and location may be altered to eliminate violations of the virtual condition. Feature size for pin **200** may be altered by first determining the interference between the pin surface **202** and the virtual condition circle **208**. The pin **200** location may be altered by determining the pin location relative to the minimum circumscribing circle for the pattern **210** and then moving the pin location.

FIG. **13** is a diagram illustrating the designed external features for an object such as a rectangular plate **310** having four spaced-apart pins **312**, **314**, **316**, **318** extending from one side of the rectangular plate **310**.

Referring to FIG. 14, in an embodiment, determining the combined remaining feature related tolerances and the amount of translation of the pattern of external features for a pattern, such as for the rectangular plate shown in FIG. 13, may comprise a step of determining **230** a true position for each of the manufactured external features. An example of step **230** may be found in the description of FIG. 3. Another step may include a step of determining **232** a framework from the true positions. An example of step **232** may be found in the description of FIG. 6. Another step may include a step of determining **234** a location for each of the manufactured external features. An example of step **234** may be found in the description of FIG. 4. Another step may include a step of determining **236** a size of each of the manufactured external features. An example of step **236** may be found in the description of FIG. 4. Another step may include a step of fitting **238** the framework to the locations of each of the manufactured external features to determine a fit framework. An example of step **238** may be found in the description of FIG. 6. Another step may include a step of relating **240** each of the manufactured external features to a transformed true position on the fit framework. An example of step **240** may be found in the description of FIG. 8. Another step may include a step of organizing **242** each of the manufactured features relative to a one true position. An example of step **242** may be found in the description of FIG. 8. Another step may include a step of determining **246** the positional error for each of the manufactured features relative to the one true position. An example of step **246** may be found in the description of FIG. 8.

Referring also to FIG. 15 and following the discussion of FIG. 14, determining the combined remaining feature related tolerances and the amount of translation of the pattern of external features for a pattern may include a step of determining **248** a minimum circumscribing circle for each of the manufactured features, a step of determining **250** a region contained within the organized plurality of manufactured external features, a step of determining **252** a minimum circumscribed circle that contains the region, a step of determining **253** the diameter of the minimum circumscribed circle, and a step of determining **254** the remaining feature related tolerance from the minimum circumscribed circle.

FIG. 15 is a diagram illustrating an embodiment of the step of determining **250** a region contained within the organized plurality of manufactured external features, as well steps **252**, **253** and **254** described in FIG. 14. The surface features **320**, **322**, **324**, **326** of four manufactured pins **312**, **314**, **316**, **318**, respectively, are shown superimposed about a one true position **330**. A minimum circumscribing circle **332** is drawn that encompasses each of the four superimposed manufactured pins **312**, **314**, **316**, **318**. The diameter D_9 of the minimum circumscribing circle **332** may represent the utilized diameter of the four manufactured pins **312**, **314**, **316**, **318**. The location of the center **334** of the minimum circumscribing circle **332** relative to the one true position **330** may indicate the amount of translation of the pattern of manufactured pins **312**, **314**, **316**, **318** relative to the fit framework. The difference in area or diameter between the minimum circumscribing circle **332** and the virtual condition circle **336** equals the amount of remaining allowable feature relating tolerance. If the minimum circumscribing circle **332** is larger than the virtual condition circle **336**, then the pattern of manufactured pins **312**, **314**, **316**, **318** violate the virtual condition.

FIG. 16 is a diagram illustrating another embodiment of the step of determining **250** a region contained within the

organized plurality of manufactured external features described, as well steps **252**, **253** and **254** described in FIG. 14. The four manufactured pins **312**, **314**, **316**, **318**, respectively, are shown superimposed about a one true position **330**. Circumscribing circles **352**, **354**, **356**, **358** are drawn for each of the manufactured pins **312**, **314**, **316**, **318**, respectively. A minimum circumscribing circle **340** is drawn that includes each of the four circumscribing circles **312**, **314**, **316**, **318**. The diameter D_{10} of the minimum circumscribing circle **340** may represent the utilized diameter of the four manufactured pins **312**, **314**, **316**, **318**. The location of the center **342** of the minimum circumscribing circle **340** relative to the one true position **330** may indicate the amount of translation of the pattern of manufactured pins **312**, **314**, **316**, **318** relative to the fit framework. The difference in diameter between the minimum circumscribing circle **340** and the virtual condition circle **336** equals the amount of remaining allowable feature relating tolerance.

It should be understood, of course, that the foregoing relates to preferred embodiments of the invention and that modifications may be made without departing from the spirit and scope of the invention as set forth in the following claims.

I claim:

1. A machine-readable medium for programming a computer to determine positional error and remaining feature related tolerance for a plurality of manufactured internal features on an object, said medium including processor executable instructions comprising:

- determining a true position for each of said plurality of manufactured internal features;
- determining a framework from said true positions;
- determining a location for each of said plurality of manufactured internal features;
- determining a size of each of said plurality of manufactured internal features;
- fitting said framework to said locations of each of said plurality of manufactured internal features to determine a fit framework;
- determining the transformed relationship between the framework and the fit framework;
- determining a relation for each of said plurality of manufactured internal features to said fit framework;
- organizing each of said relations into a single association;
- organizing the location of each of said plurality of manufactured internal features relative to said single association;
- determining said positional error for each of said manufactured internal features from said single association;
- determining a common region contained within said organized plurality of manufactured internal features;
- determining a maximum inscribed circle within said region;
- determining the diameter of said maximum inscribed circle;
- determining the center location of said maximum inscribed circle;
- determining the transformation of the center location of said maximum inscribed circle from said single association; and
- determining said remaining feature related tolerance from said maximum inscribed circle.

2. The machine-readable medium of claim 1 where said manufactured internal features comprise a hole.

3. The machine-readable medium of claim 1 where said processor executable instruction of determining a framework from said true positions comprises

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determining positional tolerances of said features;
determining size tolerances of said features; and
selecting an origin.

4. The machine-readable medium of claim 1 where said processor executable instruction of fitting said framework to said locations of each of said plurality of manufactured internal features to determine a fit framework comprises:

determining a center for each of a plurality of manufactured holes; and

best fitting true positions of said manufactured holes to said centers of said manufactured hole.

5. The machine-readable medium of claim 1 where said processor executable instruction of determining the transformed relationship between the framework and the fit framework comprises:

determining a translation of the fit framework relative to the framework; and

determining a rotation of the fit framework relative to the framework.

6. The machine-readable medium of claim 1 where said processor executable instruction of determining a relation for each of said plurality of manufactured internal features to said fit framework comprises

determining a center for a plurality of manufactured holes;

determining transformed true positions for each of said manufactured holes; and

determining locations of said centers of said manufactured holes from said transformed true positions.

7. The machine-readable medium of claim 1 where said processor executable instruction of organizing each of said relations into a single association comprises

superimposing transformed true positions.

8. The machine-readable medium of claim 1 where said processor executable instruction of organizing the location of each of said plurality of manufactured internal features relative to said single association comprises organizing the location of manufactured holes relative to a one true position.

9. The machine-readable medium of claim 1 where said plurality of manufactured internal features is simulated manufactured internal features.

10. A machine-readable medium for programming a computer to determine positional error and remaining hole related tolerance for a plurality of manufactured holes on an object, said medium including processor executable instructions comprising:

determining a true position for each of said plurality of manufactured holes;

determining a feature related tolerance zone framework (FRTZF) from said true positions;

determining a center for each of said plurality of manufactured holes;

determining a size of each of said plurality of manufactured holes;

fitting said FRTZF to said centers of said plurality of manufactured holes to determine a best fit framework;

determining a transformed true position for each of said plurality of manufactured holes;

superimposing each of said transformed true positions to form a one true position;

determining the location of each of said plurality of manufactured holes relative to said one true position;

determining a common region contained within said manufactured holes represented about said one true position;

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determining a first maximum inscribed circle within said common region;

determining the diameter of said first maximum inscribed circle;

determining a center location of said first maximum inscribed circle; and

determining said remaining hole related tolerance from said maximum inscribed circle.

11. The machine-readable medium of claim 10 where said processor executable instruction of determining a feature related tolerance zone framework (FRTZF) from said true positions comprises

providing allowable size tolerances; and

providing positional tolerances.

12. The machine-readable medium of claim 10 where said plurality of manufactured internal features is simulated manufactured internal features.

13. The machine-readable medium of claim 10 where said processor executable instruction of determining a center for each of said plurality of manufactured holes comprises

acquiring the dimensions of said manufactured holes with a measuring device;

determining a second maximum inscribed circle for each of said manufactured holes; and

determining a center for each of said second maximum inscribed circles.

14. The machine-readable medium of claim 10 where said processor executable instruction of determining a size of each of said plurality of manufactured holes comprises analyzing said plurality of manufactured holes with a measuring device.

15. The machine-readable medium of claim 10 where said processor executable instruction of determining a common region contained within said manufactured holes represented about said one true position comprises

acquiring dimensions of each of said manufactured holes; and

determining a common area within each of said manufactured holes.

16. The machine-readable medium of claim 15 where said processor executable instruction of determining said remaining hole related tolerance from said maximum inscribed circle comprises

providing a virtual condition for said manufactured holes; and

determining the difference between the diameter of the first maximum inscribed circle and said virtual condition.

17. The machine-readable medium of claim 10 where said processor executable instruction of determining a common region contained within said manufactured holes represented about said one true position comprises

acquiring dimensions of each of said manufactured holes;

determining a second maximum inscribed circle for each of said manufactured holes; and

determining a common area within each of said second maximum inscribed circles.

18. The machine-readable medium of claim 17 where said processor executable instruction of determining said remaining hole related tolerance from said maximum inscribed circle comprises

providing a virtual condition for said manufactured holes; and

determining the difference between the diameter of the first maximum inscribed circle and the virtual condition.

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19. A machine-readable medium for programming a computer to determine positional error for a plurality of manufactured holes on an object, said medium including processor executable instructions comprising:

- determining a true position for each of said plurality of manufactured holes;
- determining a framework from said true positions;
- determining a center for each of said plurality of manufactured holes;
- fitting said framework to said centers of said plurality of manufactured holes to determine a best fit framework;
- determining a transformed true position for each of said plurality of manufactured holes;
- determining a one true position from said transformed true positions;
- determining the location of each of said plurality of manufactured holes relative to said one true position;
- determining a common region contained within said manufactured holes represented about said one true position;
- determining a first maximum inscribed circle within said common region;
- determining the center of said first maximum inscribed circle; and
- determining the location of said center of said first maximum inscribed circle relative to said one true position.

20. The machine-readable medium of claim **19** where said processor executable instruction of determining a framework from said true positions comprises

- providing allowable size tolerances;
- providing positional tolerances; and
- determining a feature related tolerance zone framework (FRTZF).

21. The machine-readable medium of claim **19** where said processor executable instruction of determining a center for each of said plurality of manufactured holes comprises

- acquiring the dimensions of said manufactured holes with a measuring device; and
- determining the center of said manufactured holes from said dimensions.

22. The machine-readable medium of claim **19** where said processor executable instruction of determining a center for each of said plurality of manufactured holes comprises

- acquiring the dimensions of said manufactured holes with a coordinate measuring machine;
- determining a second maximum inscribed circle for each of said manufactured holes; and
- determining a center for each of said second maximum inscribed circles.

23. The machine-readable medium of claim **19** where said processor executable instruction of determining the size of each of said plurality of manufactured holes comprises analyzing said plurality of manufactured holes with a coordinate measuring machine.

24. The machine-readable medium of claim **19** where said processor executable instruction of determining a common region contained within said manufactured holes represented about said one true position comprises

- acquiring dimensions of each of said manufactured holes; and
- determining a common area within each of said manufactured holes.

25. The machine-readable medium of claim **19** where said processor executable instruction of determining a common region contained within said manufactured holes represented about said one true position comprises

- acquiring dimensions of each of said manufactured holes;

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determining a second maximum inscribed circle for each of said manufactured holes; and

determining a common area within each of said second maximum inscribed circles.

26. The machine-readable medium of claim **19** where said plurality of manufactured holes is simulated manufactured holes.

27. A method for determining positional error and remaining feature related tolerance for a plurality of manufactured internal features on an object, comprising:

- determining a true position for each of said plurality of manufactured internal features;
- determining a framework from said true positions;
- determining a location for each of said plurality of manufactured internal features;
- determining a size of each of said plurality of manufactured internal features;
- fitting said framework to said locations of each of said plurality of manufactured internal features to determine a fit framework;
- determining a relation for each of said plurality of manufactured internal features to said fit framework;
- organizing each of said relations into a single association;
- organizing the location of each of said plurality of manufactured internal features relative to said single association;
- determining said positional error for each of said manufactured internal features from said single association;
- determining a common region contained within said organized plurality of manufactured internal features;
- determining a maximum inscribed circle within said region;
- determining the diameter of said maximum inscribed circle; and
- determining said remaining feature related tolerance from said maximum inscribed circle.

28. The method of claim **27** where said manufactured internal features comprise holes.

29. The method of claim **27** where said step of determining a framework from said true positions comprises

- determining positional tolerances of said features;
- determining size tolerances of said features; and
- selecting an origin.

30. The method of claim **27** where said step of fitting said framework to said locations of each of said plurality of manufactured internal features to determine a fit framework comprises:

- determining a center for each of a plurality of manufactured holes; and
- best fitting said true positions of a tolerance zone framework of said manufactured holes to said centers of said manufactured hole.

31. The method of claim **27** where said step of determining a relation for each of said plurality of manufactured internal features to said fit framework comprises

- determining a center for a plurality of manufactured holes;
- determining transformed true positions for each of said manufactured holes; and
- determining locations of said centers of said manufactured holes from said transformed true positions.

32. The method of claim **27** where said step of organizing each of said relations into a single association comprises superimposing transformed true positions.

33. The method of claim **27** where said step of organizing the location of each of said plurality of manufactured

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internal features relative to said single association comprises organizing the location of manufactured holes relative to a one true position.

34. The method of claim **27** where said plurality of manufactured internal features is simulated manufactured internal features.

35. A method for determining positional error and remaining feature relating tolerance for a plurality of manufactured holes on an object, comprising:

determining a true position for each of said plurality of manufactured holes;

determining a framework from said true positions;

determining a location for each of said plurality of manufactured holes;

determining a size of each of said plurality of manufactured holes;

fitting said framework to said locations of each of said plurality of manufactured holes to determine a fit framework;

determining a relation for each of said plurality of manufactured holes to said fit framework;

organizing each of said relations into a single association;

organizing the location of each of said plurality of manufactured holes relative to said single association;

determining said positional error for each of said manufactured holes from said single association;

determining a common region contained within said organized plurality of manufactured holes;

determining a maximum inscribed circle within said region;

determining the diameter of said maximum inscribed circle; and

determining said remaining feature related tolerance from said maximum inscribed circle.

36. The method of claim **35** where said step of determining a framework from said true positions comprises

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determining positional tolerances of said manufactured holes;

determining size tolerances of said manufactured holes; and

selecting an origin.

37. The method of claim **35** where said step of fitting said framework to said locations of each of said plurality of manufactured features to determine a fit framework comprises:

determining a center for each of said manufactured holes; and

best fitting true positions of said manufactured holes to said centers of said manufactured holes.

38. The method of claim **35** where said step of determining a relation for each of said plurality of manufactured holes to said fit framework comprises

determining a center for said plurality of manufactured holes;

determining transformed true positions for each of said manufactured holes; and

determining locations of said centers of said manufactured holes from said transformed true positions.

39. The method of claim **35** where said step of organizing each of said relations into a single association comprises superimposing transformed true positions.

40. The method of claim **35** where said step of organizing the location of each of said plurality of manufactured holes relative to said single association comprises organizing the location of manufactured holes relative to a one true position.

41. The method of claim **35** where said plurality of manufactured holes is simulated manufactured holes.

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